

Work Order ID 91223

October-03-12 2:41:18 PM

91223

Page 1

Item ID: D2662-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH In 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 09/01/2013 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-10-04 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev E								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
100									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program part number and batch number. Inspect part number and batch number are programmed								
	MACHINE AS PER FOLIO FB068 & DWG DWG REV: <u>E</u> FOLIO REV: <u>AA</u>								
110	CONVENTIONAL MILLING MACHINE	0.00							
110									
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								

12/11/28

FK 12/11/29

FK 12/11/30

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

FK 12/11/29.

30 6

B.A 12/12/01

30 0

DAS
08
9-89

30 0

12.12.3.

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

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Page 3

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Item Name: Saddle, LH In 206

Stop ***NS2***

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 09/01/2013 Req'd Qty: 30.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating <i>M123383</i>	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>Memo</i> START TIME: <i>11-50</i> OVENTEMPERATURE: <i>320 F</i> FINISH TIME: <i>12-20</i>	0.00 0.00				<i>30x</i>	<i>✓</i>		<i>MJ</i> <i>12/12/04</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish <i>Memo</i>	0.00 0.00				<i>30x</i>	<i>✓</i>		<i>HL</i> <i>12/12/04</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>433</i> <i>Memo</i>	0.00 0.00				<i>30</i>			<i>12/12/04 JB</i>

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Supplier <input type="checkbox"/>											
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Page 4

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Revision ID:

Item Name: Saddle, LH In 206

Stop ***NS2***

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 09/01/2013 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/12/5 JF
ME
12-12-04

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
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		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

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Page 1

Work Order ID: 91223

91223

Parent Item: D2662-1

D2662-1

Parent Item Name: Saddle, LH In 206

Start Date: 03/10/2012

Required Date: 09/01/2013

Start Qty: 30.00

Required Qty: 30.00

Comments

IPP: C00.06.22Removed P/O for powder coatEC

IPP Rev:D As per Rev D 07-03-19 JLM

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001

Manufactured

No

100

Each

42.0000

1

30

D6101-001

**

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

38

69677

2

76836

1

81923

1

85433

11

87606

11

90152

12

MAT042

4

83309

4

91235 X30

OK 12/11/25

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; font-size: small;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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FAULT CATEGORY

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DART AEROSPACE LTD				Work Order: 91223	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-1	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.316	3.316	3.316	3.316	3.316
B	0.256	0.263		.260	.260	.260	.260	.260
C	0.315	0.322		.318	.318	.318	.318	.318
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.123	.123	.123	.123	.123
G	0.210	0.230		.223	.223	.223	.223	.223
H	0.615	0.685		.685	.685	.685	.685	.685
I	2.470	2.510		2.493	2.493	2.493	2.493	2.493
J	1.313	1.343		1.326	1.326	1.326	1.326	1.326
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.133	1.133	1.133	1.133	1.133
N	0.100	0.180		.140	.140	.140	.140	.140
O	0.100	0.140		.130	.130	.130	.130	.130
P	0.240	0.260		.252	.255	.255	.255	.255
Q	0.677	0.697		.690	.690	.690	.690	.690
R	0.540	0.560		.550	.550			
S	0.912	0.932		.925	.925	.925	.925	.925
T	0.787	0.807		.799	.799	.799	.799	.799
U	5.990	6.010		6.002	6.002	6.002	6.002	6.002
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.505	.505	.505	.505	.505
X	0.312	0.319		.316	.316	.316	.316	.316
Y	0.990	1.010		.997	.997	.997	.997	.997
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.503	.503	.503	.503	.503
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.134	.134	.134	.134	.134
AE	0.235	0.240		.237	.237	.237	.237	.237
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.112	.112	.112	.112	.112
AH	1.565	1.585		1.580	1.580	1.580	1.580	1.580
Accept/Reject								

Measured by: <u>BE</u>	Date: <u>12/11/27</u>
Audited by: <u>DA</u>	Date: <u>12/12/01</u>
Prototype Approval: <u>9-88</u>	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	<u>M</u>

DART AEROSPACE LTD				Work Order: 91223	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-1	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6 1	7 2	8 3	9 4	10 5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.260	.260	.260	.260	.260
C	0.315	0.322		.318	.318	.318	.318	.318
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.119	.119	.119	.119	.119
G	0.210	0.230		.219	.219	.219	.219	.219
H	0.615	0.685		.685	.685	.685	.685	.685
I	2.470	2.510		2.492	2.492	2.492	2.492	2.492
J	1.313	1.343		1.326	1.326	1.326	1.326	1.326
K	0.178	0.198		.187	.187	.187	.187	.187
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.132	1.132	1.132	1.132	1.132
N	0.100	0.180		.180	.180	.180	.180	.180
O	0.100	0.140		.130	.130	.130	.130	.130
P	0.240	0.260		.256	.256	.256	.256	.256
Q	0.677	0.697		.689	.689	.689	.689	.689
R	0.540	0.560		.552	.552	.552	.552	.552
S	0.912	0.932		.927	.927	.927	.927	.927
T	0.787	0.807		.800	.800	.800	.800	.800
U	5.990	6.010		6.002	6.002	6.002	6.002	6.002
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.502	.502	.502	.502	.502
X	0.312	0.319		.316	.316	.316	.316	.316
Y	0.990	1.010		.997	.997	.997	.997	.997
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.502	.502	.502	.502	.502
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.135	.138	.138	.138	.138
AE	0.235	0.240		.237	.237	.237	.237	.237
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.112	.112	.112	.112	.112
AH	1.565	1.585		1.572	1.572	1.572	1.572	1.572
Accept/Reject								

Measured by: <u>RC</u>	Date: <u>12/11/27</u>
Audited by: <u>LA</u>	Date: <u>12/12/01</u>
Prototype Approval: <u>08</u> 9-89	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	<u>M</u>

DART AEROSPACE LTD				Work Order: 91223	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-1	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.618	3.618	3.618	3.618	3.618
B	0.256	0.263		.260	.260	.260	.260	.260
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.119	.119	.119	.119	.119
G	0.210	0.230		.220	.220	.220	.222	.222
H	0.615	0.685		.680	.680	.680	.680	.680
I	2.470	2.510		2.496	2.496	2.496	2.496	2.496
J	1.313	1.343		1.326	1.326	1.326	1.326	1.326
K	0.178	0.198		.187	.187	.187	.187	.187
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.135	1.135	1.135	1.135	1.135
N	0.100	0.180		.180	.180	.180	.180	.180
O	0.100	0.140		.128	.128	.128	.128	.128
P	0.240	0.260		.254	.254	.254	.254	.254
Q	0.677	0.697		.689	.689	.689	.689	.689
R	0.540	0.560		.552	.552	.552	.552	.552
S	0.912	0.932		.922	.922	.922	.922	.922
T	0.787	0.807		.797	.797	.797	.797	.797
U	5.990	6.010		6.001	6.001	6.001	6.001	6.001
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.501	.501	.501	.501	.501
X	0.312	0.319		.316	.316	.316	.316	.316
Y	0.990	1.010		.997	.997	.997	.997	.997
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.501	.501	.501	.501	.501
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.135	.135	.135	.135	.135
AE	0.235	0.240		.237	.237	.237	.237	.237
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.112	.112	.112	.112	.112
AH	1.565	1.585		1.580	1.580	1.580	1.580	1.580
Accept/Reject								

Measured by: 36	Date: 12/11/28
Audited by: B.A. 08	Date: 12/12/01
Prototype Approval: 9-88	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	

DART AEROSPACE LTD		Work Order:	91223
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-1
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
A	3.611	3.621		3.614	3.614	3.614	3.614	3.614
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.119	.120	.119	.119	.124
G	0.210	0.230		.219	.219	.219	.219	.222
H	0.615	0.685		.685	.685	.685	.685	.685
I	2.470	2.510		2.491	2.491	2.491	2.491	2.491
J	1.313	1.343		1.324	1.323	1.323	1.323	1.326
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		.132	1.132	1.133	1.1345	1.139
N	0.100	0.180		.140	.140	.140	.140	.140
O	0.100	0.140		.121	.121	.119	.121	.119
P	0.240	0.260		.255	.251	.251	.252	.251
Q	0.677	0.697		.687	.687	.687	.687	.687
R	0.540	0.560		.551	.550	.551	.550	.550
S	0.912	0.932		.922	.922	.922	.921	.922
T	0.787	0.807		.797	.797	.797	.797	.798
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.502	.500	.502	.502	.503
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		.997	.996	.995	.996	.997
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.499	.498	.498	.498	.498
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.134	.132	.131	.134	.135
AE	0.235	0.240		.237	.237	.237	.237	.237
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.112	.112	.112	.112	.112
AH	1.565	1.585		1.574	1.574	1.575	1.576	1.580
Accept/Reject								

Measured by: F.k	Date: 12/11/29.
Audited by: J.A	Date: 12/12/01
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	

DART AEROSPACE LTD				Work Order: 91223	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-1	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				21	22	23	24	25
A	3.611	3.621		3.614	3.614	3.614	3.614	3.614
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.121	.120	.120	.120	.120
G	0.210	0.230		.221	.220	.220	.220	.220
H	0.615	0.685		.685	.685	.685	.685	.685
I	2.470	2.510		2.491	2.491	2.491	2.491	2.491
J	1.313	1.343		1.325	1.325	1.324	1.324	1.323
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.135	1.135	1.134	1.134	1.135
N	0.100	0.180		.140	.140	.140	.140	.140
O	0.100	0.140		.121	.120	.120	.120	.121
P	0.240	0.260		.251	.252	.251	.252	.253
Q	0.677	0.697		.687	.687	.687	.688	.687
R	0.540	0.560		.550	.550	.550	.550	.550
S	0.912	0.932		.921	.922	.922	.922	.922
T	0.787	0.807		.797	.797	.797	.797	.797
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.502	.503	.502	.502	.502
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		.995	.995	.995	.996	.996
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.498	.498	.498	.498	.498
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.134	.134	.133	.133	.134
AE	0.235	0.240		.237	.237	.237	.237	.237
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.112	.112	.113	.113	.113
AH	1.565	1.585		1.576	1.575	1.575	1.575	1.5745
Accept/Reject								

Measured by: F.K.	Date: 12/11/29
Audited by: J.A.	Date: 12/12/01
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	

DART AEROSPACE LTD				Work Order: 91223	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-1	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 1	

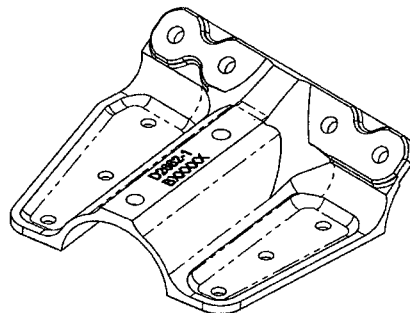
FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				26	27	28	29	30
A	3.611	3.621		3.614	3.614	3.614	3.614	3.614
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.120	.120	.120	.120	.120
G	0.210	0.230		.219	.219	.219	.220	.221
H	0.615	0.685		.685	.685	.685	.685	.685
I	2.470	2.510		2.491	2.491	2.491	2.491	2.491
J	1.313	1.343		1.323	1.323	1.323	1.323	1.326
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.1335	1.133	1.132	1.1335	1.135
N	0.100	0.180		.140	.140	.140	.140	.140
O	0.100	0.140		.121	.119	.121	.121	.121
P	0.240	0.260		.252	.251	.253	.253	.253
Q	0.677	0.697		.687	.687	.687	.687	.687
R	0.540	0.560		.551	.550	.550	.550	.550
S	0.912	0.932		.922	.922	.922	.922	.922
T	0.787	0.807		.797	.797	.797	.798	.797
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.502	.502	.502	.502	.502
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		.996	.996	.996	.996	.995
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.500	.498	.498	.498	.498
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.132	.134	.135	.133	.133
AE	0.235	0.240		.237	.237	.237	.237	.237
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.112	.114	.114	.114	.114
AH	1.565	1.585		1.574	1.575	1.573	1.575	1.576

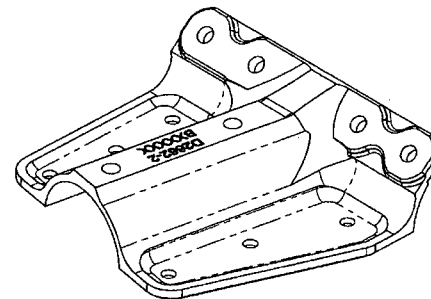
Accept/Reject

Measured by: EK	Date: 12/11/29
Audited by: B.A.	Date: 12/12/01
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

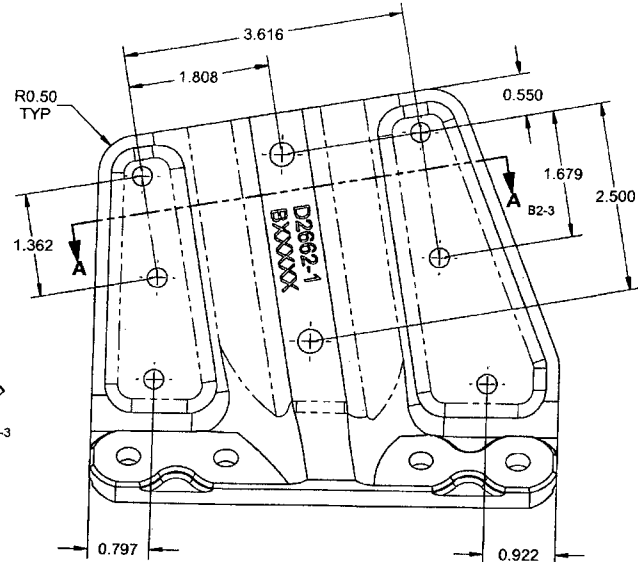
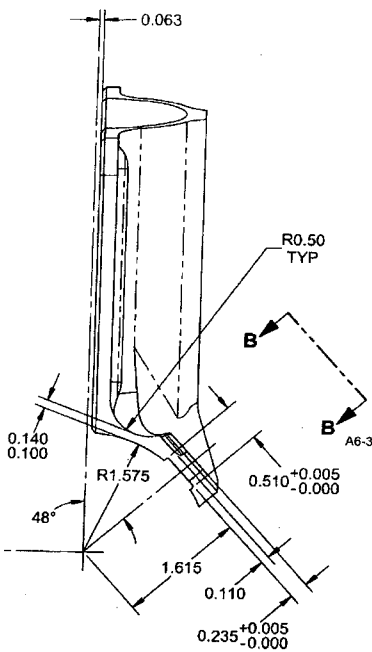
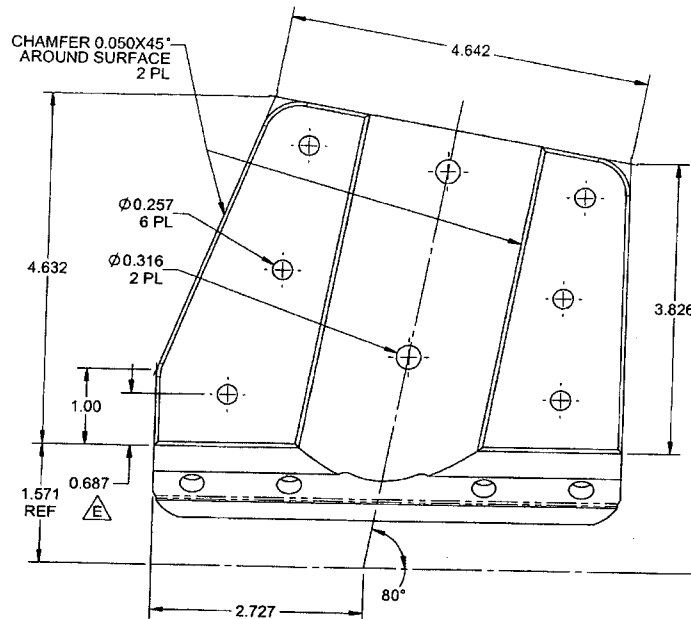
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ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDM
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WORK ORDER

NO. **91223 MCT**
12-10-04

RELEASED
2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP' DEO 9122/9102/9085/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

91223



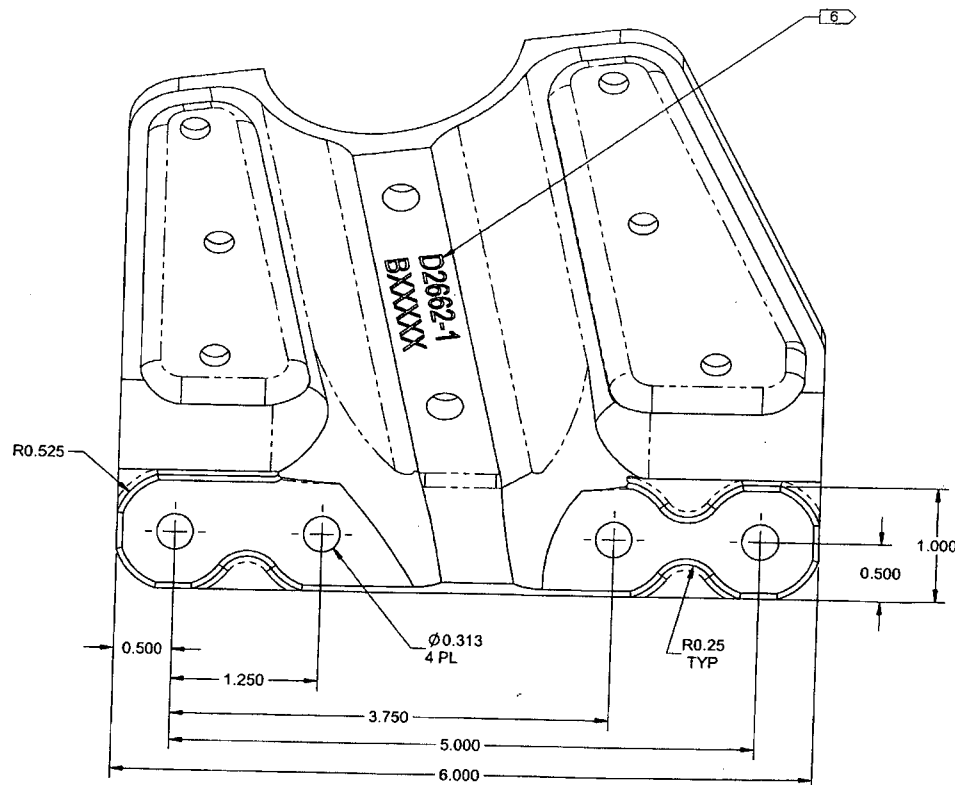
D2662-1 SADDLE, INSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

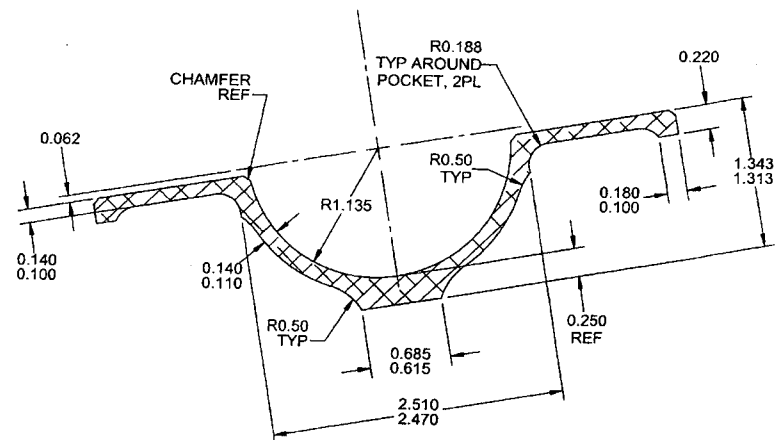
RELEASE
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

91223



VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED

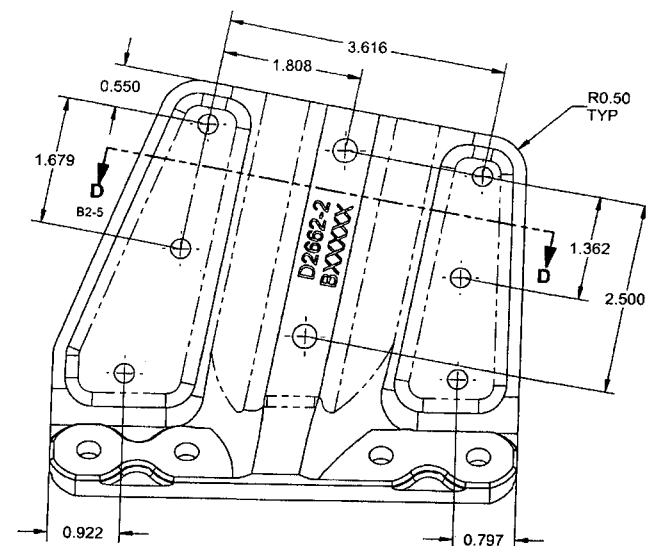
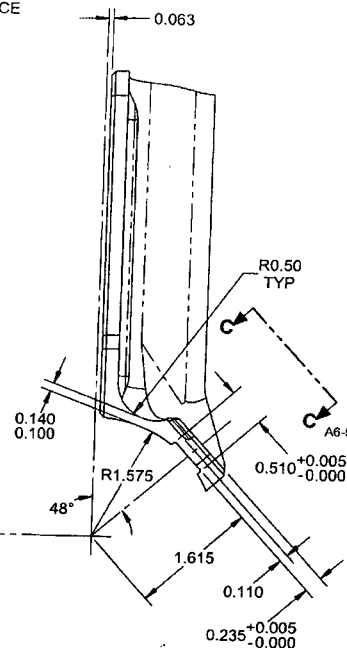
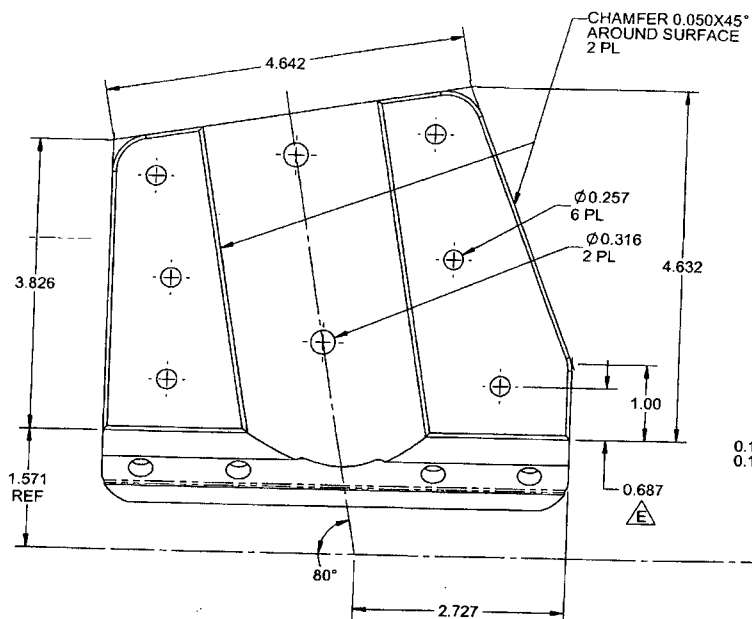


VIEW A-A
SCALE 1.5X C1-2

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2011-11-16

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	90	KENT, WA	
CHECKED	ASS	DRAWING NO. D2662	REV. E
MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		SADDLE, INSIDE	SCALE
DE APPR.			NTS
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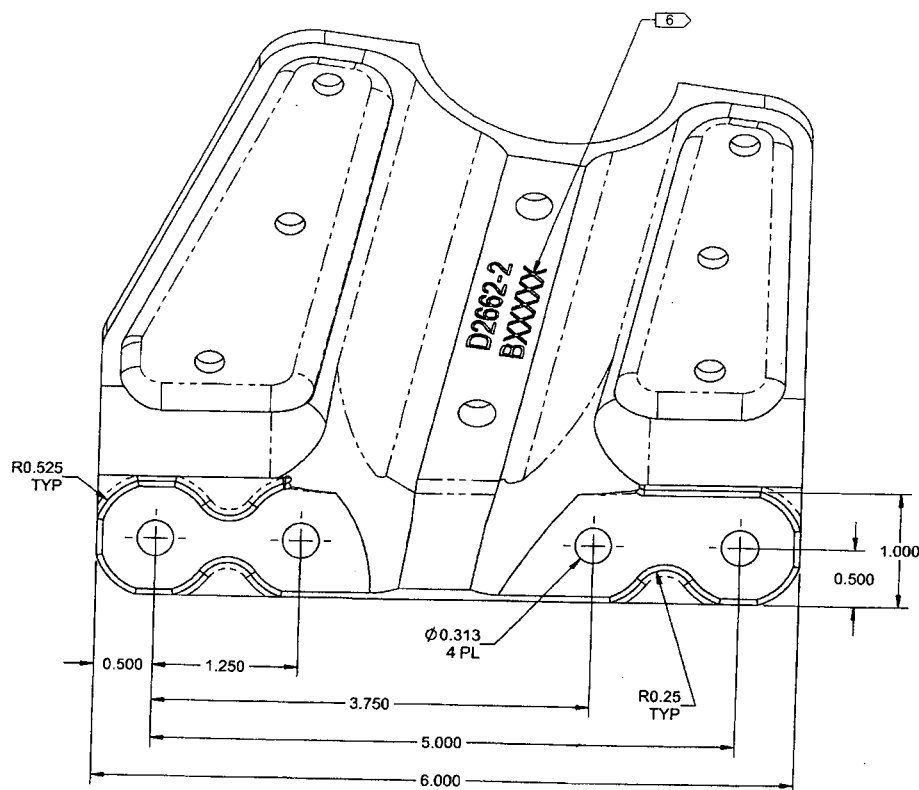
RELEASED
2011-11-16

D2662-2 SADDLE, INSIDE, RH

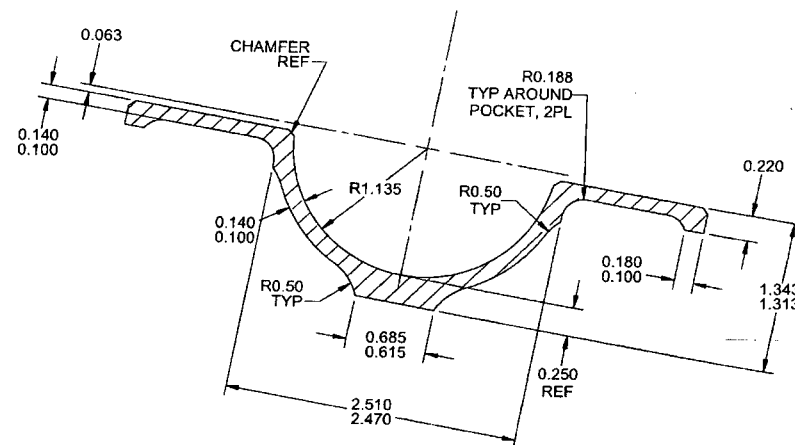
- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

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DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2662	REV. E
MFG. APPR.		TITLE	SHEET 4 OF 5
APPROVED		SADDLE, INSIDE	SCALE
DE APPR.			NTS
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VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



VIEW C-C C3-4
SCALE 1.5X

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2011-11-16

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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 5 OF 5
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